

Amendments to the Claims:

This listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

1. (Currently Amended) A method for manufacturing a pleated filter material from a thermally bonded non woven fabric, comprising :

forming a single fibrous web from undrawn and drawn synthetic fibers;

pre-heating the fibrous web;

calendering the single fibrous web between non-heated profiled calender rolls in a single calendering step without subsequent re-heating, wherein during the single calendering step, the undrawn fibers in the single fibrous web ~~are bonded~~ form bonds in a tension free manner between the non-heated profiled calender rolls to form the non woven fabric, wherein ~~no portion of the bonds of the non woven fabric are of equal strength is bonded more strongly over its cross-section, wherein than the remainder of the non woven fabric such that the non woven fabric is formed without inhomogeneities over the cross section of the non woven fabric and~~ without the use of flat bonding, and wherein during the single calendering step, spacers are formed in the non woven fabric to thereby form the filter material.